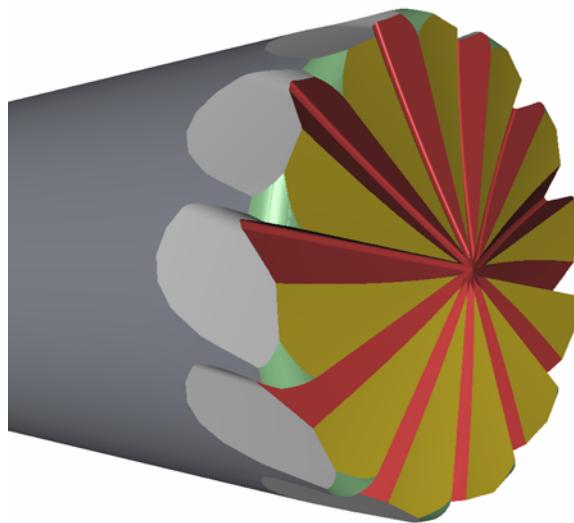


Radius Endmill Ø20 Z12 R2

A01-102



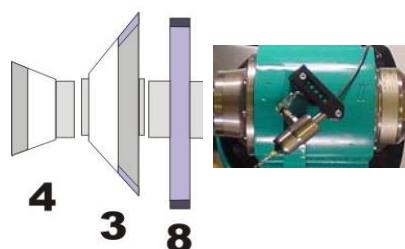
1. Cycletime for Production

Tool specifications				
Diameter 20 mm, Z 12, Length of cutting edge 10 mm, Helix angle 25°				
Material CARBIDE				
Operations				
Flute 1	100	120	150	120
Feed [mm/Min]	4	2	2	2
Power [kW]	18	32	24	24
Cutting feed [m/s]				
Used wheels	8	7	4	4
Grinding time [s]	161	141	106	54
Total cycle time	7 Min 41			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

8 Ø125 1A1 D64
3 Ø125 12V9 D64
4 Ø75 11V9 D64



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : Sirius HPM
Control: Fanuc 310i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto

responsible engineer: KCM

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

TECHNOLOGY
FOR TOOLING